

**Work Order ID 70818**

Page 1

Wednesday, June 15, 2011 2:27:17 PM

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/15/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date: 106/15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

304 . 40

Memo

1-Cut as per Dwg D3535

 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

B11-7-4

(16)

110



QC2- Inspect parts off machine-FAI/FAIB

QC

Quality Control

0.00

B11-7-4

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

0.00

S 6/6/15

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

NC BRAKE

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Brake NC

Memo

0.00

16

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326  
2-Form  
joggle as per Dwg D3535 using Jig DT8158  
3-Identify as D3535-23

SB 11/07/05

140



QC

QC5- Inspect part completeness to step on W/O

0.00

S 11/07/05

Quality Control

Memo

0.00

16

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

2:10

0.00

FINISH TIME:

2:10

OVEN TEMPERATURE:

2:40

16x Ø m 11/07/05

M 11/5/28

320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 70818**

Wednesday, June 15, 2011 2:27:17 PM



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Item ID: D3535-23

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/15/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC3- Inspect Part Finish

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

F-P 21

0.00

16 6 21 07/05

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

16 6 21 07/05

MF 11-07-06

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Page 1

Wednesday, June 15, 2011 2:27:24 PM

Work Order ID: 70818



Parent Item: D3535-23



Parent Item Name: Wearshoe

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	236.6630	1.3615	22.93053			

304/316 .040 Sheet



Location	Loc Qty	Loc Code
MAT020	236.663	
116623	0.2	
117550	9.363	
117933	227.1	117933

B11-7-4

16

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70818
Description: Wearshoe	Part Number:	D3535-23
Inspection Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.886	x		V B02	
2.000	+/-0.010	2.000	x		V	
4.750	+/-0.010	4.756	x		T B01	
9.500	+/-0.010	9.500	x		T	
14.250	+/-0.010	14.250	x		T	
17.750	+/-0.010	17.750	x		T	
23.140	+/-0.010	23.140	x		T	
28.530	+/-0.010	28.530	x		T	
33.920	+/-0.010	33.920	x		T	
39.310	+/-0.010	39.310	x		T	
44.700	+/-0.010	44.706	x		T	
48.200	+/-0.010	48.200	x		T	
52.850	+/-0.010	52.850	x		T	
Ø0.188	+0.005/-0.001	.190	x		V	
48.00	+/-0.030	48.00	x		T	
39.00	+/-0.030	39.00	x		T	
32.00	+/-0.030	32.00	x		T	
24.00	+/-0.030	24.00	x		T	
16.00	+/-0.030	16.00	x		T	
8.00	+/-0.030	8.00	x		T	
6.00	+/-0.030	6.00	x		T	
0.300	+/-0.010	.304	x		V	
0.300	+/-0.010	.306	x		V	
0.038	+/-0.010	.035	x		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-7-14	Date:	11/07/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	S

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**DART**

DESIGN C.B	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 3 OF 7 1:10 SCALE

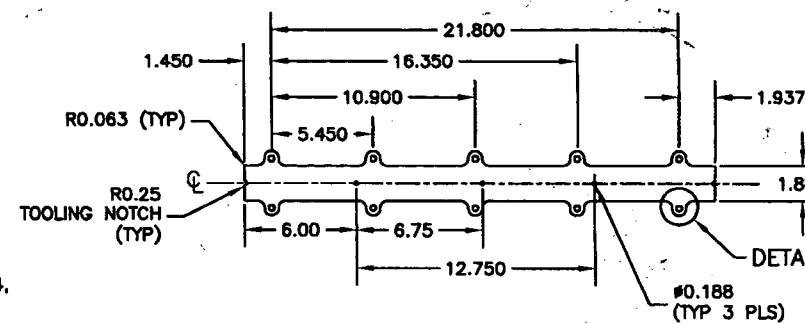
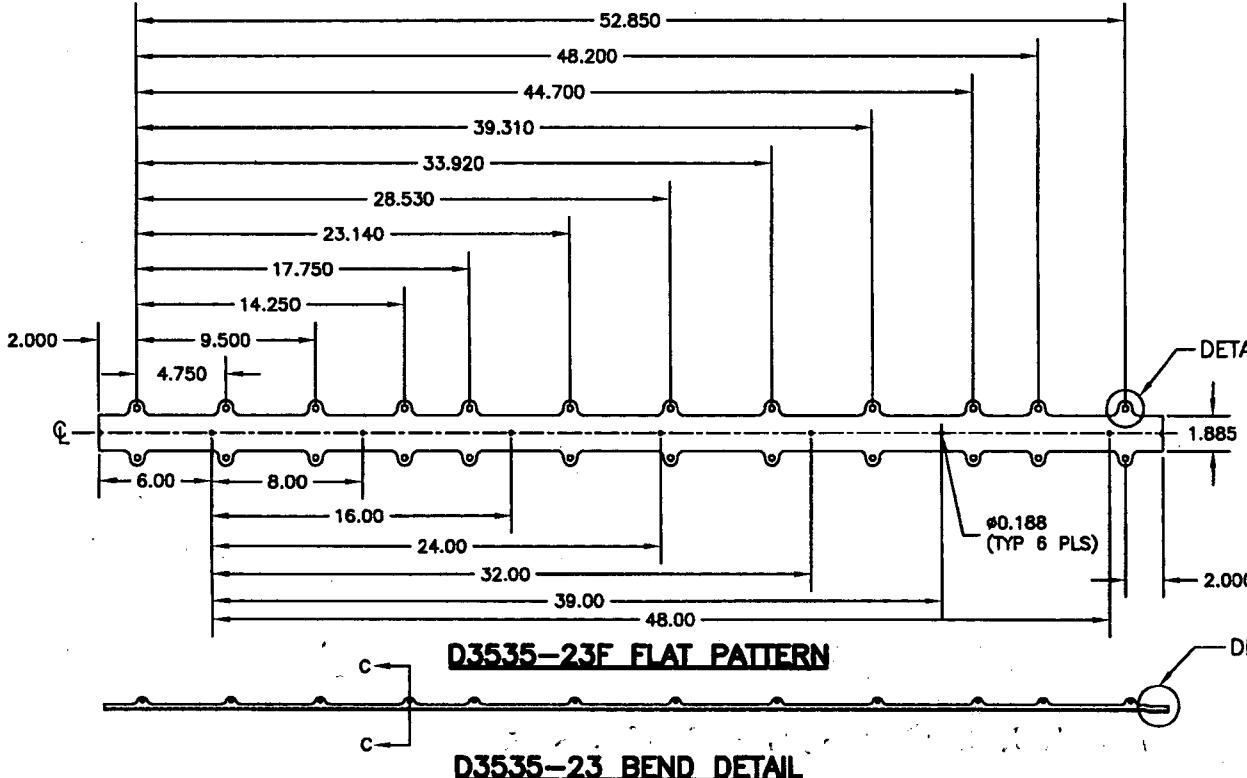
RELEASED  
07.04.24  
*PH*

SHOP COPY

RETURN TO  
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 70818*PH-0615***NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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